

Date: Monday, 22/09/2008 1:03:20 PM
 User: Julie Lecocq

Process Sheet

20
13
14

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING			
Job Number	: 42171						
Estimate Number	: 11396						
P.O. Number	:			Part Number	: D32993		
This Issue	: 22/09/2008	S.O. No. :		Drawing Number	: D3299 REV B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type :	MACHINED PARTS	Drawing Revision	: B		
Previous Run	: 41829			Material	:		
Written By	:			Due Date	: 29/09/2008		
Checked & Approved By	: <u>JUL 08.9.22</u>			Qty:	20	Um: Each	
Comment	: Est: A 04.10.04 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6H1000	6061-T6 HexBar 1.00	
		Comment: Qty.: 0.1925 f(s)/Unit Total : 3.8493 f(s) 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <u>M105238</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: Machine as per Folio FA452 and Dwg D3299	
		Check NPT THREAD WITH SAMPLE IN TOOLING RACK UNDER D3399-1 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH	
		Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: <u>7303</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:03:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 42171

Part Number: D32993

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>8/10/20 (2e)</i>
7.0	QC5	INSPECT WORK TO CURRENT STEP
		 <i>8/10/20 (f2c) created</i>
	Comment: INSPECT WORK TO CURRENT STEP	
8.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <i>26x</i>
	Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: <u>82</u>	<i>8/10/20 (20)</i>
9.0	QC21	FINAL INSPECTION/W/O RELEASE
		 <i>08/10/22 JF</i>
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



JMF 08-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4271
Description: Fitting	Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

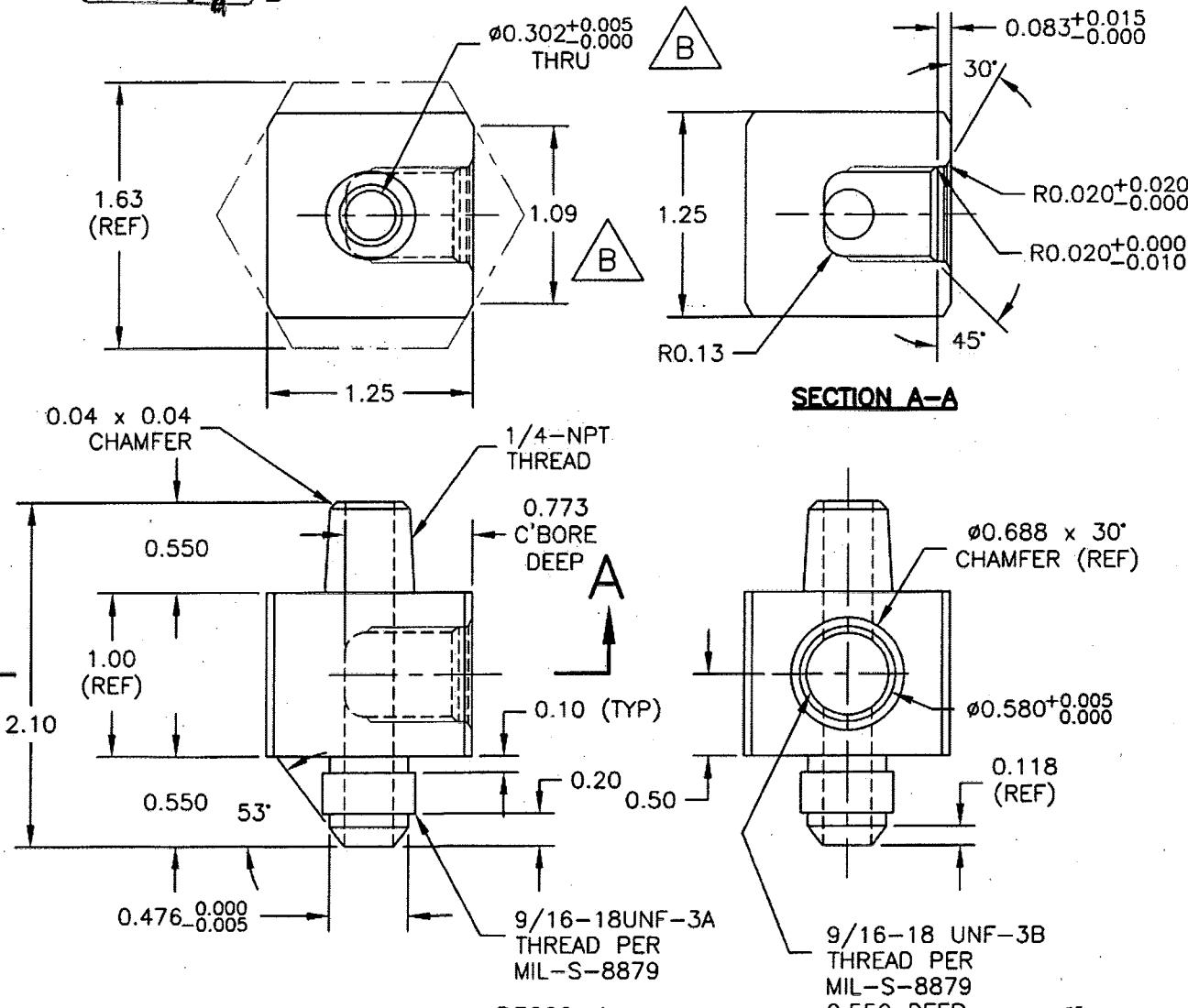
Measured by: SA	Audited by: SP	Prototype Approval: N/A
Date: 08/10/01	Date: 08/10/01	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	



DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>PF</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; ϕ 0.302 WAS ϕ 0.297	

RELEASED
05.04.28



D3299-1

D3299-1 NOTES:

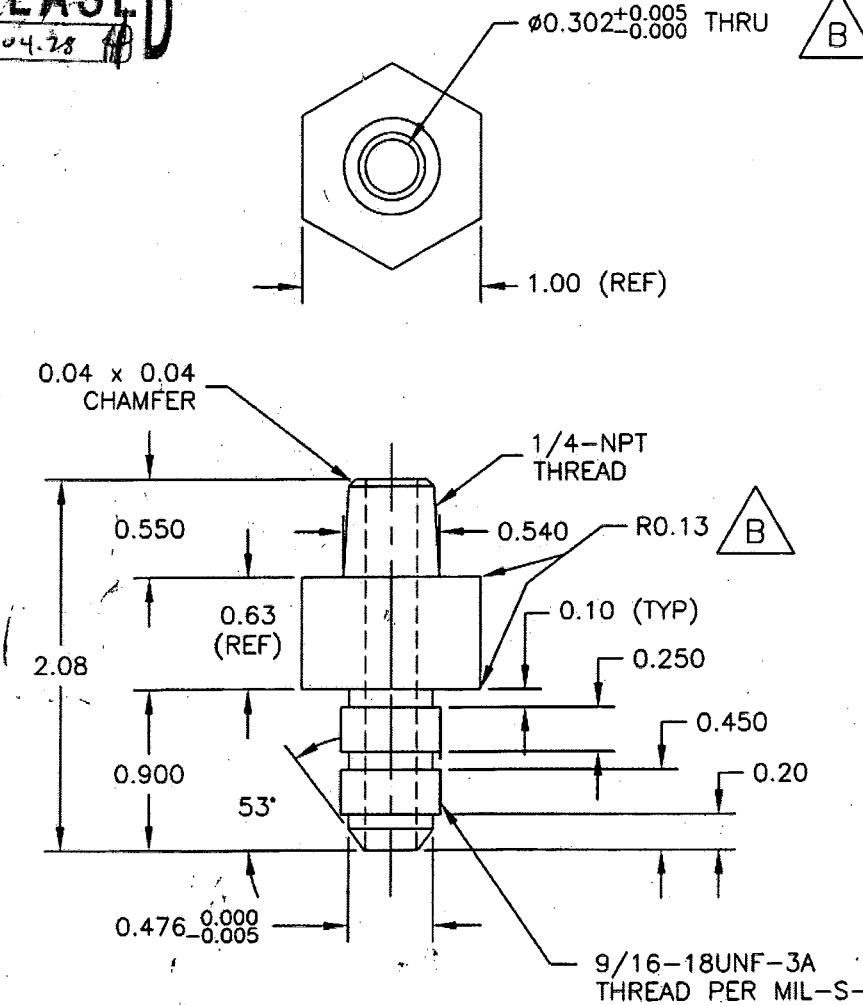
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061-~~611625~~)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR UB CLASS
- 3) POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER NO. 12211

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3299	SHEET 2 OF 3
DATE		TITLE	SCALE
05.04.28		FITTING	1:1

RELEASED
05.04.28**D3299-3****D3299-3 NOTES:**

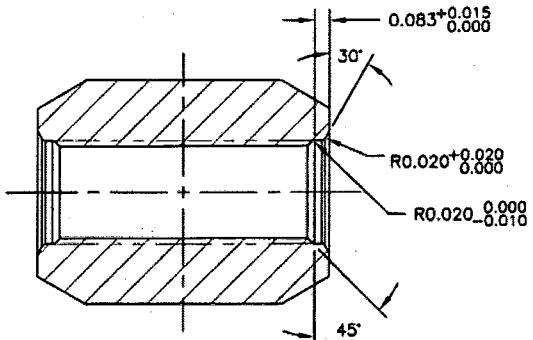
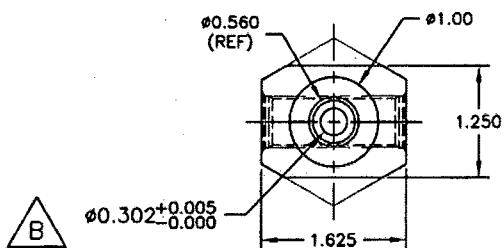
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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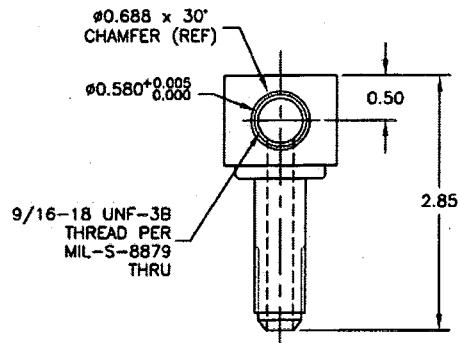
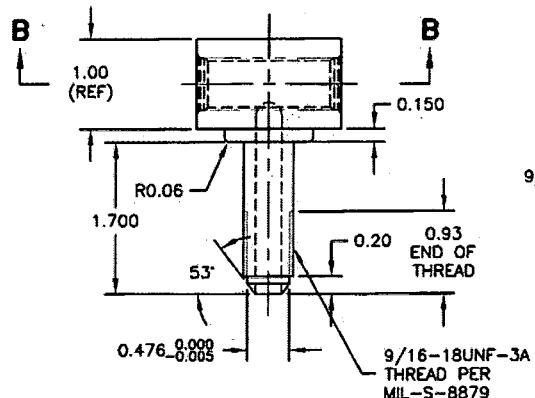


DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28 *#*



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

68833

07-Oct-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 7303/214680
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	20	20	D3299-3 B 42171	BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

S
05/05/08

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité Manager Q.C.